

Work Order ID 150760

Friday, September 02, 2016 8:40:00 AM

150760

Page 1

Item ID: D119-796-101

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: FWD Crosstube Installation with Step

Start Date: 9/2/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/2/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: dm Date: 16/09/02 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9730	B								
IIN-D119-796	F								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D119-796-101 CHG004								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89

SEP 02 2016

SEP 02 2016

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Picklist Print

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150760

Parent Item: D119-796-101

D119-796-101

Parent Item Name: FWD Crosstube Installation with Step

Start Date: 9/2/2016

Required Date: 9/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM IPP REV:B
14.10.22 AS PER PA1 DD VERF:JLM IPP REV:C 14.11.19
AS PER IIN REV.B DD VERF:JLM IPP REV:D 15.02.12 PER REV
C JLM VERIFIED BY:DD IPP REV:E 15.05.13 PER REV D JLM
VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-796-151

Manufactured

No

Each

1.0000

1

D119-796-151

FWD Crosstube Installation with Step (no hardware)

B147579

Location

Loc Qty

Loc Code

FG

1

147579

1

D3672-7

Manufactured

No

Each

899.0000

8

D3672-7

Washer, Phenolic

PC

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

359

147220

359

ST057A

500

149431

500

SEP 02 2016

DQA: _____ Date: _____



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OTHER : ☐					

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Parent Item: D119-796-101

D119-796-101

Parent Item Name: FWD Crosstube Installation with Step

Start Date: 9/2/2016

Required Date: 9/2/2016

Start Qty: 1.00

Required Qty: 1.00

AN5C32A

Purchased

No

Each

107.0000

4

AN5C32A

BOLT

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

4

18918

4

over004

100

131650

100

ST336

3

m132102

3

Each

61.0000

4

MS21250-05048

Purchased

No

MS21250-05048

Bolt (use MS21250-05-048)

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST295

61

m134973

26

m135482

35

Each

223.0000

12

AN5C7A

Purchased

No

AN5C7A

BOLT

**

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

2

19185

2

FP001

30

m132930

30

over003

150

m131320

150

ST338

41

m131139

7

m132123

34

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150760

Parent Item: D119-796-101

D119-796-101

Parent Item Name: FWD Crosstube Installation with Step

Start Date: 9/2/2016

Required Date: 9/2/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

Each

144.0000

4

MS21043-5

Nut

**

PC

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG
101418

20
20

GA
116548

72
72

ST302

52

m135157
m135470

2
50

4

NAS1149C0532R

Purchased

No

Each

384.0000

8

NAS1149C0532R

WASHER

**

PC

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA
116513

60
60

ST260a

200

m135390

200

ST266

124

m134756
m135056

18
106

8

NAS1149C0563R

Purchased

No

Each

446.0000

12

NAS1149C0563R

Washer

**

PC

DAS
26
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

446

m131697

446

12

SEP 02 2016

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OTHER : _____					

5.0 PARTS LIST

5.1 STANDARD GEAR CROSSTUBES

Item	-101	-201	-103	-203	-141	-241	-151	-251	Part Number	Description
	X								D119-796-101	FWD CROSSTUBE INSTALLATION WITH PEG STEPS
		X							D119-796-201	AFT CROSSTUBE INSTALLATION WITH PEG STEPS
			X						D119-796-103	FWD CROSSTUBE INSTALLATION W/O PEG STEPS
				X					D119-796-203	AFT CROSSTUBE INSTALLATION W/O PEG STEPS
			1		X		1		D119-796-141	CROSSTUBE INSTALLATION, STANDARD FWD, W/O PEG STEPS
				1		X		1	D119-796-241	CROSSTUBE INSTALLATION, STANDARD AFT, W/O PEG STEPS
	1						X		D119-796-151	CROSSTUBE INSTALLATION, STANDARD FWD, WITH PEG STEPS
		1						X	D119-796-251	CROSSTUBE INSTALLATION, STANDARD AFT, WITH PEG STEPS
1					4	4			D2873-043	RADIUS BLOCK
2	8	8	8	8					D3672-7	WASHER
3						1			D5122-1	CENTER SUPPORT
4						6			D5123-1	CLAMP CUSHION
5					4		4	4	D5123-3	CLAMP CUSHION
6						2			D5123-5	CLAMP CUSHION
7					2				D5124-1	FWD SUPPORT
8						1			D5134-041	DAMPER SUPPORT ASSY, LH
9						1			D5134-042	DAMPER SUPPORT ASSY, RH
10						1			D5136-1	CONTACT PAD, LH
11						1			D5136-2	CONTACT PAD, RH
12							2		D5149-041	FWD STEP ASSY
13								2	D5149-043	AFT STEP ASSY
14					2				D5152-041	FWD POST MOUNT ASSY
15						2			D5152-043	AFT POST MOUNT ASSY
16						16			CR3212-4-07	RIVET
17					16				CR3212-4-08	RIVET
18							4		MS21920-22	CLAMP
19					4				MS21920-24	CLAMP
20						6		4	MS21920-25	CLAMP
21		2		2		2			MS21920-28	CLAMP
22	4	4	4	4					AN5C32A	BOLT
23	4	4	4	4					MS21250-05048	BOLT
24	12	12	12	12					AN5C7A	BOLT
25	4	4	4	4					MS21043-5	NUT
26	8	8	8	8					NAS1149C0532R	WASHER
27	12	12	12	12					NAS1149C0563R	WASHER
100		1		1					DP460	SCOTCH WELD ADHESIVE (37mL)